

Work Order ID 71756

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Monday, July 11, 2011 10:50:18 AM

Item ID: D3996-FE-832-EF

Accept



Setup Start



Revision ID:

Stop



Item Name: Self-Clinching Fastener

Start Date: 7/11/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals:

Process Plan:

CL

Date: 11/07/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3996

A

100

0.00



Purchasing

Memo

0.00

Purchasing

Issue P/O:

14451

Purchase Part Number: FE-832-EF

Supplier: Interfast Inc.

Certificate of conformity is required

CL 11/07/11 100

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

11/7/12 100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71756

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Item ID: D3996-FE-832-EF

Accept



Setup Start



Revision ID:

Stop



Item Name: Self-Clinching Fastener

Start Date: 7/11/2011 Start Qty: 100.00



Cust Item ID:

Required Date: 7/15/2011 Req'd Qty: 100.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Accept Qty: 11
Reject Qty: 07
Reject Number: 12
Insp. Stamp: 100

130

Identify as per dwg & Stock Location: 285 0.00

Packaging

Memo

0.00

Packaging

Accept Qty: 11/7/12sf
Reject Qty: 102

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

Accept Qty: 11/7/13sf
Reject Qty: 11-07/3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Monday, July 11, 2011 10:50:15 AM

Work Order ID: 71756



Parent Item: D3996-FE-832-EF



Parent Item Name: Self-Clinching Fastener



Start Date: 7/11/2011

Required Date: 7/15/2011

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP RevA: new issue 09.11.11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
FE-832-EF  PEM Insert		Purchased	No			110	Each	0.0000	1 	100		7/11/12	(100)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

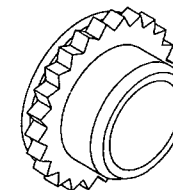
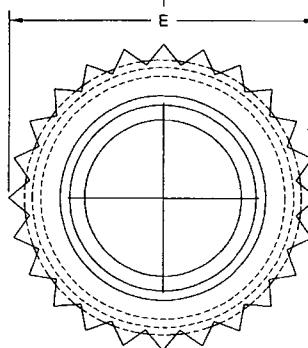
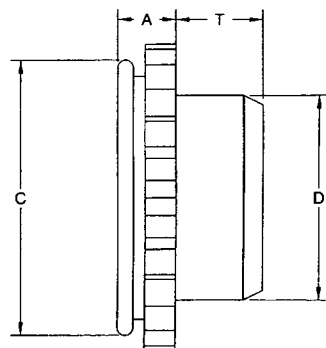
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING



D3996-XXX-YYY-ZZZ SELF-CLINCHING FASTENER

THREAD SIZE	THREAD CODE ("YYY")	TYPE ("XXX")	A MAX (SHANK)	SHEET THICKNESS	C +0.000 -0.005	D MAX	E ±0.005	T +0.015 -0.000	HOLE SIZE IN SHEET +0.003/-0.000	MIN DIST: HOLE CL TO EDGE	WEIGHT lb
#4-40 (0.112)	440	FEO	0.040	0.039-0.045	0.171	0.145	0.192	0.065	0.172	0.14	0.00031
		FE	0.060	0.059-0.070							0.00037
#6-32 (0.138)	632	FEO	0.040	0.039-0.045	0.212	0.180	0.244	0.075	0.213	0.17	0.00047
		FE	0.060	0.059-0.070							0.00068
#8-32 (0.164)	832	FEO	0.040	0.039-0.045	0.289	0.215	0.322	0.090	0.290	0.20	0.00098
		FE	0.060	0.059-0.070							0.00124
#10-32 (0.190)	032	FEO	0.040	0.039-0.045	0.289	0.245	0.322	0.110	0.290	0.20	0.00104
		FE	0.060	0.059-0.070							0.00120
1/4-28	0428	FE	0.060	0.059-0.070	0.343	0.318	0.384	0.120	0.344	0.28	0.00158

NOTES

1) SPECIFICATION: PENNINGENGINEERING (PEM) MINIATURE SELF-CLINCHING FASTENER, SELF-LOCKING
PEM P/N XXX-YYY-ZZZ

WHERE "XXX" = TYPE "FEO" (SHORT SHANK) OR "FE" (LONG SHANK) PER TABLE
"YYY" = THREAD CODE PER TABLE
"ZZZ" = FINISH CODE PER NOTE 2 BELOW

FOR EXAMPLE, #8-32 THREAD, LONG SHANK, ELECTRO-FILM FINISH:
DART P/N = D3996-FE-832-EF
PEM P/N = FE-832-EF

2) FINISH: FINISH CODE ("ZZZ") PER THE FOLLOWING:

"C" = CADMIUM YELLOW CHROMATE PER ASTM B766 CLASS 5 TYPE II
"Cl" = CADMIUM CLEAR CHROMATE PER ASTM B766 CLASS 5, TYPE III
"EF" = ELECTRO-FILM PER MIL-PRF-46010
"MD" = MOLYBDENUM DISULFIDE DRY FILM (STD PEM FINISH)

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: N/A

7) WEIGHT: N/A

CL11107111
W10: 71756

RELEASED
2009-11-08

A	NEW ISSUE	CP	09.10.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3996	REV. A
TITLE SELF-CLINCHING FASTENER	SCALE NTS
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14452

Purchase Order Date 7/11/2011

PO Print Date 7/11/2011

Page Number 1 of 1

Order From :

VC-INT001

INTERFAST INC.
22 WORCESTER ROAD
TORONTO, ON M9W 5X2
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	416 674 0770	Requisition Nbr	
Vendor Fax	416 674 5804	Tax Resale Nbr	10127-2607
Vendor Account Nbr	110900	Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED
CL 11/07/11

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	FE-832-EF	PEM Insert	7/15/2011 Yes	100.00 Each	FedEx PI collect	\$0.3000	\$30.00

Special Inst: AS PER DWG D3996 REV. A
B71756
P/N:FE-832-EF

PO Total: \$30.00

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 7/11/2011

CL

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



22 WORCESTER ROAD, TORONTO, ON, CAN, M9W 5X2
TEL: 1-416-674-0770 FAX: 416-674-5804
WEBSITE: www.interfast.ca

Packing Slip

PACK-SLIP REV: NC DATE: 09/30/03



Invoice#:

606200

11-JUL-11

SV DART AEROSPACE LIMITED
OE 1270 ABERDEEN ST.
LN HAWKESBURY ON
DD K6A 1K7
U CAN
T
OA

SE DART AEROSPACE LIMITED
HX 1270 ABERDEEN ST.
IP HAWKESBURY ON
PE CAN K6A 1K7
D
TI
OE
R
A

SHIP MODE: Fedex Domestic Within Canada
MODE D'EXPEDITION:

FOB: FOB - Interfast Dock
F.A.B.:

NO. CARTONS: 1

WAYBILL #: 485453256735
FACTURE DE VOIE #:

CUSTOMER PO#: PO14452
N° DU BON DE COMMANDE:
CUSTOMER #: 110900
CLIENT #:
OUR SALE #: 535031
N° DE LA VENTE:
TERMS: Net 30 Days (01)
MODALITES:

QUANTITY ORDERED QUANTITÉ COMMANDÉE	U/M M.N.R	QUANTITY SHIPPED QUANTITÉ EXPÉDIÉE	BALANCE DUE SOLDE	PART# & DESCRIPTION PARTIE # ET DESCRIPTION	LOT# / Serial#
100.00	EA	100.00	0.00	Cust PO Line#: Cust Part#: FE-832-EF Part#: FE-832-EF Description: NUT ** Packbox#: PACK526786 Lot Line#: 1 Qty: 100 Expire Date Country Of Origin: USA	D502640001
Harmonized code:		7318.16.00.90			

Total Qty Shipped: 100

GST/TPS # R102504958 QPST/TVQ #1009982431TQ0001

PAST DUE ACCOUNTS WILL BE SUBJECT TO A SERVICE CHARGE OF 1.5% PER MONTH. INTERFAST WILL BE RESPONSIBLE FOR THE AUTHORIZED REPLACEMENT OF GOODS WHICH ARE DEFECTIVE OR WHICH ARE NOT TO SPECIFICATION PROVIDED THAT CLAIMS ARE MADE WITHIN 14 DAYS OF SHIPMENT.

LES COMPTES EN SOUFFRANCE SERONT ASSUJETTIS À DES FRAIS DE SERVICE DE 1.5% PAR MOIS. INTERFAST NE SERA RESPONSABLE QUE POUR L'ÉCHANGE AUTORISÉ DE BIENS DÉFECTUEUX OU QUI NE SONT PAS CONFORMES AUX SPÉCIFICATIONS À CONDITION QUE LES RÉCLAMATIONS SOIENT EFFECTUÉES DANS LES QUATORZE (14) JOURS SUIVANT L'EXPÉDITION.

Dave Dawkins

Dave Dawkins
Manager Of Quality



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